

# Work Order ID 85881

June-18-12 10:47:08 AM

**\*85881\***

Page 1

Item ID: D205-634-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 18/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

MLJ

Date: 12/06/18

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580-041

(DEO) Rev.E

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG005

**DAS**  
**16**  
**2-83**

12/17/18

MLJ 12-7-30

110

0.00

**\*110\***

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

CF 12-7-23

**85881**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**\*1\***

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Required Date: 04/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

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Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for welding as per QSI 004								
130	QC5- Inspect part completeness to step on W/O	0.00							
<b>*130*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

CF 12.7.23

1 2 20724



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 04/07/2012 Req'd Qty: 1.00

**\*1\***

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00

**\*140\***

Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R Aluminum Rod

*M12230 BE 12/07/24*

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimation.

4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Debur

5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

*1 0 CF 12-1-24*

150

QC10- Inspect visual per QSI004- ground welds

0.00

**\*150\***

QC

Memo

0.00

Quality Control

*DAS 16 9-89 12/07/25*

*(70)*

W/O:		WORK ORDER CHANGES					
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Required Date: 04/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

DAS  
16  
2-8- 12/07/25

Quality Control

170

Pressure Wash per QSI005 4.3

0.00

**\*170\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 76 12-7-25

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*180\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

2:30  
320 °F  
3:00

IX 12/07/25

M121841

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 18/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp.  
Qty Qty Number Stamp

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Memo

0.00

Quality Control

1  $\phi$  B2 12-7-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 18/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

0.00

**\*200\***

HandFinish

0.00

Memo

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates  
A/R Sikaflex-291 12/1/30  
Sikaflex expire date: 14-3

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive  
A/R Sikaflex-291 12/1/30  
Sikaflex expire date: 14-03

5-Wing Walk as per Dwg D2580 and QSI 005 4.4  
Batch: 12165

1 0 12-7-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Replacement Skidtube

Start Date: 18/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00

**\*210\***

QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

0.00

**\*220\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: 1-6073

PPP Rev: \_\_\_\_\_

230

QC21- Final Inspection - Work Order Release

0.00

**\*230\***

QC

Memo

0.00

Quality Control

DAS  
16  
9-89 12/1/27

12/7/310

12/8/1178

MLJ 12/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D205-634-041\***

Parent Item Name: Replacement Skidtube

Start Date: 18/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30  
 KJ IPP Rev P 10.02.19  
 per PAR09-043 EC verified by:DD  
 IPP Rev. O 06.02.28 Added paperwork EC  
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q  
 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS  
 PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 <b>*D4202-1*</b> Spacer		Manufactured	No			140	Each	224.0000	20	20			
									**	20		CF 12-7-24	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				184					
				77727				5					
				83263				179					
				LG002				40					
				78806				6					
				79810				34					
D2580-1 <b>*D2580-1*</b> 205 Skidtube bent detail		Manufactured	No			110	Each	4.0000	1	1			
									**	1		CF 12-7-23	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				4					
				76570				2					
				77679				2					
D2576-3 <b>*D2576-3*</b> Step (maching detail)		Manufactured	No			140	Each	76.0000	1	1			
									**			BE 12-07-24	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				76					
				74136				24					
				82257				52					

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D205-634-041

**\*D205-634-041\***

Parent Item Name: Replacement Skidtube

Start Date: 18/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

21.0000

1

1

**\*D2855\***

\*\*

BR 12-7-26.

Cap

Location

Loc Qty

Loc Code

FP002

84952

21

65519

2

73347

16

75074

3

AN3-5A

Purchased

No

200

Each

964.0000

2

2

**\*AN3-5A\***

\*\*

BR 12-7-26.

Bolt

Location

Loc Qty

Loc Code

ST350

964

115371

46

117423

124

118626

31

119355

200

120187

500

121185

63

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

0.0000

2

2

**\*AN960JD10L \***

\*\*

2. BR 12-7-26.

Washer

121011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Replacement Skidtube

Start Date: 18/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

2,108.000

50

50

**\*AI S7-1032-130\***

\*\*

Insert

BR 12-7-26

Location

Loc Qty

Loc Code

ST280

122174

51

117

117717

27

118966

22

119775

2

ST282

2057

119530

73

120181

12

121444 ✓

1972

3

AN3C4A

Purchased

No

200

Each

945.0000

50

50

**\*AN3C4A\***

\*\*

BOLT

BR 12-7-26

Location

Loc Qty

Loc Code

ST350

122151

945

46

120187

31

120521

28

122156 122116

120769

38

121205

832

121556

16

AN960C10L

NAS1149C0332

Purchased

No

200

Each

21.0000

50

50

**\*AN960C10I \***

\*\*

washer

BR 12-7-26

Location

Loc Qty

Loc Code

ST

122063

21

50

107534

21

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 18/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3566-13

Manufactured No

200

Each

56.0000

1

1

**\*D3566-13\***

**\*\***

Gasket

*BR 12-7-26.*

Location

Loc Qty

Loc Code

FP

10

83351

10

FP002

46

76947

1

84880 ✓

45

D3566-5

Manufactured No

200

Each

52.0000

1

1

**\*D3566-5\***

**\*\***

Gasket

*BR 12-7-26.*

Location

Loc Qty

Loc Code

FP

10

82275

10

FP002

42

80374

3

82274 ✓

6

84881

33

D3566-1

Manufactured No

200

Each

93.0000

2

2

**\*D3566-1\***

**\*\***

Gasket

*BR 12-7-26.*

Location

Loc Qty

Loc Code

FP

-32

FP002

125

68924

2

80919

3

83898

16

84879 ✓

72

*2*

W/O:		WORK ORDER CHANGES					
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Parent Item: D205-634-041

**\*D205-634-041\***

Parent Item Name: Replacement Skidtube

Start Date: 18/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-11

Manufactured No

200

Each

26.0000

1

1

**\*D3564-11\***

Wearshoe

\*\*

BR 12-7-26.

Location

Loc Qty

Loc Code

FG

84872

4

77056

4

FP001

22

83910

22

D3564-13

Manufactured No

200

Each

23.0000

1

1

**\*D3564-13\***

Wearshoe

\*\*

BR 12-7-26.

Location

Loc Qty

Loc Code

FP001

1

71594

1

FP002

22

82249 ✓

22

D3564-9

Manufactured No

200

Each

18.0000

1

1

**\*D3564-9\***

Wearshoe

\*\*

BR 12-7-26.

Location

Loc Qty

Loc Code

FG

85474

4

76938

4

FP001

14

67590

4

69943

1

82255

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June-18-12 10:47:13 AM

Page 6

Work Order ID: 85881

**\*85881\***

Parent Item: D205-634-041

**\*D205-634-041\***

Parent Item Name: Replacement Skidtube

Start Date: 18/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200 Each

36.0000 1 1

**\*D3564-5\***

Wearshoe

\*\*

*BR 12-7-26*

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

34

77609

1

82254

8

84869 ✓

25

D2594-3

Manufactured No

200 Each

2,410.000 16 16

**\*D2594-3\***

O-Ring, 205 Skidtube

\*\*

*BR 12-7-26*

Location

Loc Qty

Loc Code

FP001

2410

65518

41

79496

984

79573

50

79755 ✓

1335

D2594-1

Manufactured No

200 Each

713.0000 16 16

**\*D2594-1\***

Plug, 205 Skidtube

\*\*

*BR 12-7-26*

Location

Loc Qty

Loc Code

FP001

98

73401

30

74442

18

79495

50

FP-A

615

73401

0

78590

205

84951 ✓

410

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

LIST OF MATERIALS					
ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	DESCRIPTION
1	X			D2580-041	SKIDTUBE ASSEMBLY
2		X		D2580-045	SKIDTUBE ASSEMBLY
3			X	D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1	D2500-1-190	EXTRUSION
5			16	D2570	BUSHING
6	1	1	1	D2576-3	STEP
7	20	24	25	D2579	SPACER
8	16	16	8	D2594-1	PLUG
9	16	16	8	D2594-3	O-RING
10	1	1	1	D2596	205 WEB
11	1	1	1	D2855	AFT CAP
12	1	1		D3564-5	WEARSHOE
13	1	1		D3564-9	WEARSHOE
14	1	1		D3564-11	WEARSHOE
15	1	1		D3564-13	WEARSHOE
16	2	2		D3566-1	GASKET
17	1	1		D3566-5	GASKET
18	1	1		D3566-13	GASKET
19			1	D4406-041	WEARPLATE ASSEMBLY
20			1	D4406-043	WEARPLATE ASSEMBLY
21	50	50		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50		AN3C4A	BOLT
23	2	2	2	AN3-5A	BOLT
24			8	AN4-45A	BOLT
25	50	50		NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)
27			8	MS21042-4	NUT (OR MS21042L4)

# GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs  
D2580-045 = 34.5 lbs  
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

DEO ATTACHED

RELEASED  
2011-08-29

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 85881 MLJ  
12/06/18

E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	#		
DRAWN	RF		
CHECKED	10		
MFG. APPR.	10		
APPROVED	10		
DE APPR.	10		
DATE	11.06.21		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2580  
REV. E  
SHEET 1 OF 8  
TITLE 205 SKIDTUBE ASSEMBLY  
SCALE NTS

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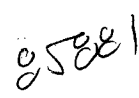
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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RELEASED  
2011-08-29  
WDP



DETAIL C D3-2  
SCALE 5X

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. E
D2580	SHEET 2 OF 8
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

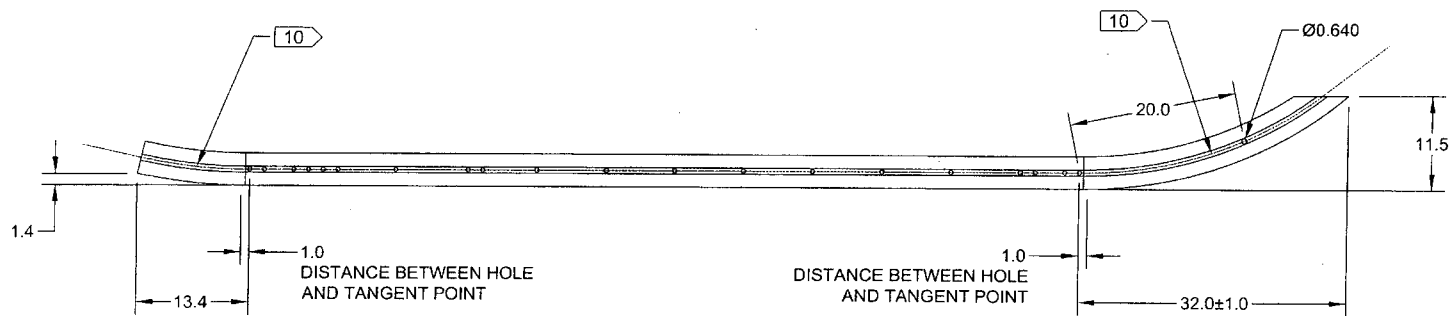
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

25881



D2580-1 BENT TUBE  
(MAKE FROM D2580-101 TUBE)

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DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 3 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

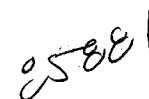
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

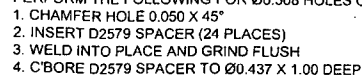
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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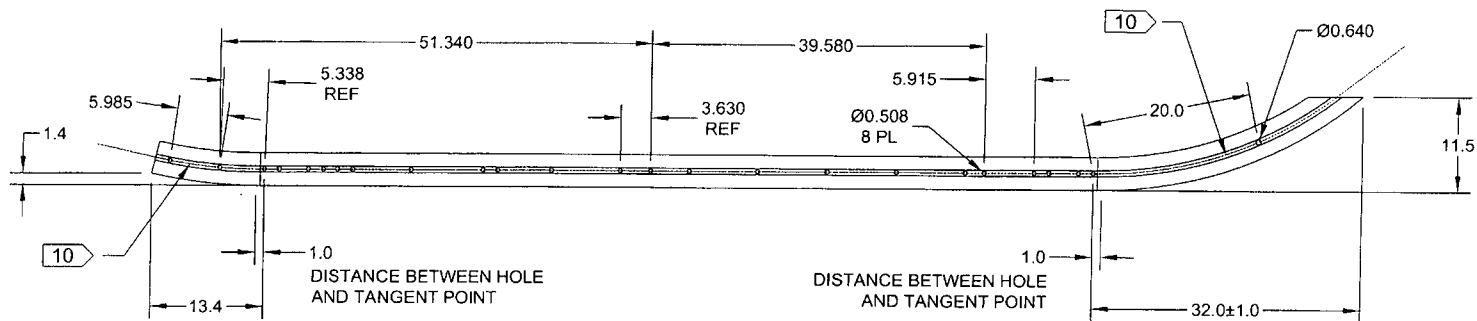
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2580-5 BENT TUBE**  
(MAKE FROM D2580-101 TUBE)

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AN

DESIGN	#	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. E
MFG. APPR.	140	D2580	SHEET 5 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	140	205 SKIDTUBE ASSEMBLY	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

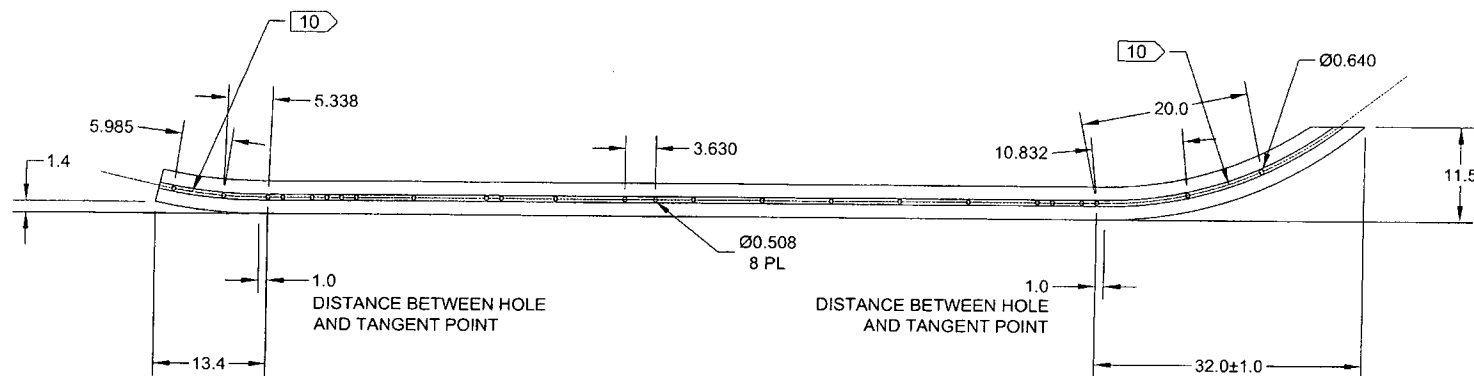
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

25801



D2580-7 BENT TUBE  
(MAKE FROM D2580-101 TUBE)



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DRAWN	RF		
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MFG. APPR.	10	D2580	SHEET 7 OF 8
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

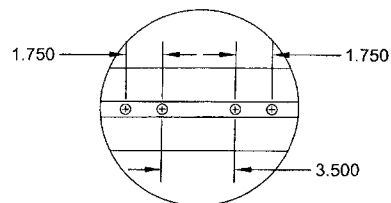
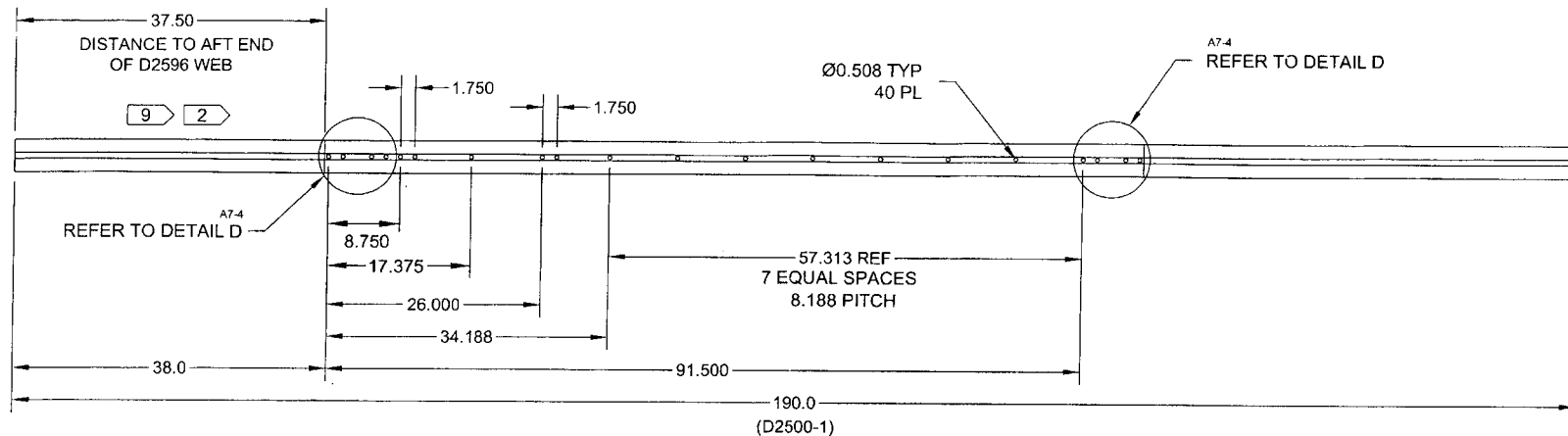
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**NOTE:** Date & initial all entries



25881



**DETAIL D** D3-4  
C7-4  
SCALE 5X

D2580-101 TUBE

DEO ATTACHED  
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2011-08-29

DESIGN	#	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	NO	DRAWING NO.	REV. E
MFG. APPR.	NO	D2580	SHEET 8 OF 8
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. E	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D2580-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>EC</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 11.12.13	DATE 11.12.13	DATE 11.12.13	DATE 11.12.13	DATE 11.12.13		

**PURPOSE:**

CHANGE ALL C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

*25881*

**CHANGE:**

PARTS LIST IS AMENDED AS FOLLOWS:

WAS

QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045	-047		
20	24	25	D2579	CROSS BOLT SPACER

IS

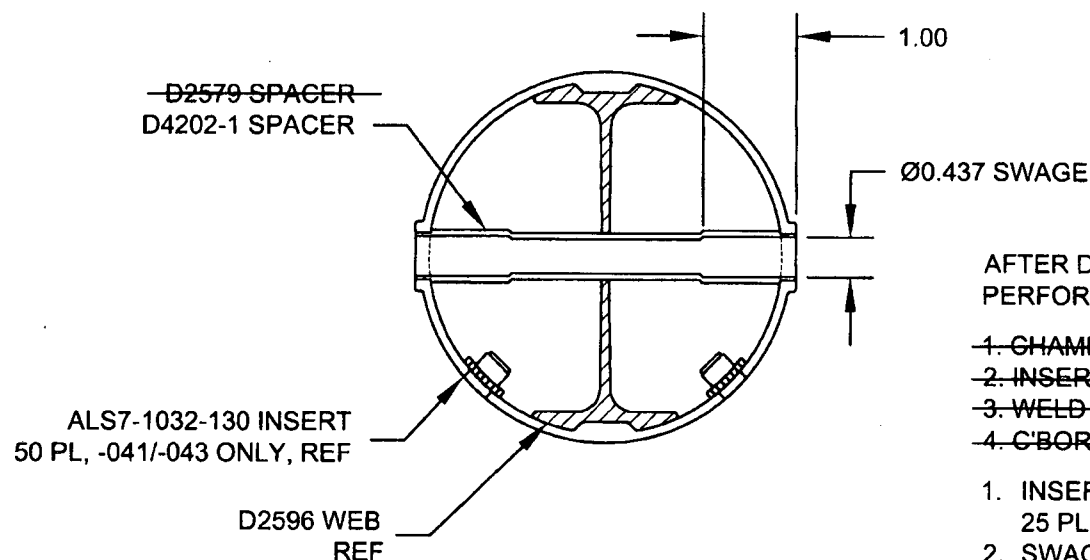
	4		* D2579	CROSS BOLT SPACER
20	20	25	D4202-1	SPACER

**\* FOR -045 SKIDTUBE ONLY:**

WELD 4X D2579 SPACERS PER DWG  
IN LOCATIONS MARKED "NO C'BORE".  
REF SHEET 4 OF DWG.

SECTION B-B, SECTION F-F, & SECTION I-I ARE AMENDED AS FOLLOWS  
FOR ALL HOLES THAT WERE ORIGINALLY C'BORED:

**RELEASED**  
2011-12-14 *[Signature]*



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

- ~~1. CHAMFER HOLE 0.050 X 45°~~
- ~~2. INSERT D2579 SPACER (20 PLACES)~~
- ~~3. WELD INTO PLACE AND GRIND FLUSH~~
- ~~4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP~~

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 20 PL (-045) OR 25 PL (-047)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

**SECTION B-B, F-F, I-I**  
NOT TO SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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